

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008600**Date Inspected:** 24-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu yang/ Mr. Xu le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 070140 perform FCAW welding on, Doubler plate of Skin E, Lift 4, Weld joint no. WSD1-FESA4-4 D/F- 5. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-TC-P4-F.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066459 perform SMAW welding on, Spare strut web to flange, Weld joint no. WD1-A 6001-3-13. ZPMC CWI Identified as Mr. Xu zhen rong. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2113.

Bay no. 10

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 051413 perform SAW welding on, Strut splice plate, Weld joint no. ED1-A 5007-17-1A. ZPMC CWI Identified as Mr. Ma yun. The welding parameters as measured using QC's calibrated instruments appeared to be in general

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compliance with WPS-B-T-3221-TC-U5-S1.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on, Spare strut flange to web, Weld joint no. ED1-A 6003-3-12A. ZPMC CWI Identified as Mr. Ma yun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2212-tc-u3b-1.

### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member is identified as Diagonal stiffener with triangular plate of South tower, Lift 3, CD Corner, Bay no. 10. The weld designations reviewed are as follows:

SSTL3- 1B/K - Jt. - 3  
SSTL3- 1C/K - Jt. - 3, 94  
SSTL3- 1D/K - Jt. - 3  
SSTL3- 1F/K - Jt. - 3, 79  
SSTL3- 1G/K - Jt. - 3, 94  
SSTL3- 1H/K - Jt. - 3, 78  
SSTL3- 1I/K - Jt. - 3, 93

### Visual Inspection Testing:

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as West tower, Lift 3, 111.67 mtr./ 102.5 mtr./ 105.5 mtr. Diaphragm to skin A/E, Fit lugs. The weld designations reviewed are as follows:

WSTL3- 4 H/K- 45, 46, 121, 122, 28, 29, 103, 104  
WSTL3- 4 J/K- 50, 51, 28, 29  
WSTL3- 4 H/K- 32 to 44, 153, 107 to 120, 20 to 27, 95 to 102  
WSTL3- 4 J/K- 36 to 49  
WSTL3- 4 J/K- 24 to 27, 30 to 33

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

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No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar, Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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